

Page 1

Packaging

4 of 14-02 13

④ 14.02.14

4 ϕ $\frac{14}{14.02.10}$

Work Order ID 111109

Thursday, January 09, 2014 11:29:38 AM

111109

Page 2

Item ID: PB67-43001-21 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Blade Support And Cover Assembly
Start Date: 1/8/2014 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/24/2014 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

_____ 14-02-19 _____

MF
14-2-18

Picklist Print

Thursday, January 09, 2014 11:29:38 AM

Work Order ID: 111109

Parent Item: PB67-43001-21

Parent Item Name: Upper Blade Support And Cover Assembly

Start Date: 1/8/2014

Required Date: 1/24/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec
dwg EC verified by:DD
IPP Rev B 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-10 SCREW		Purchased	No			100	Each	256.0000	10	20		1/14.02.13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		100							
				120449		100							
				ST506		156							
				m126474		156							
NAS1149D0316J Washer		Purchased	No			100	Each	135.0000	10	20		1/14.02.13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST294		135							
				123482		135							
NAS1149D0363J Washer		Purchased	No			100	Each	3,689.0000	12	24		1/14.02.13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		154							
				124392		154							
				ST510a		3535							
				m126319		2335							
				m127813		1200							
PB67-43001-173 Cover Plate		Manufactured	No			100	Each	9.0000	1	2		1/14.02.13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		9							
				99994		9							

Picklist Print

Thursday, January 09, 2014 11:29:38 AM

Page 2

Work Order ID: 111109

Parent Item: PB67-43001-21

Parent Item Name: Upper Blade Support And Cover Assembly

Start Date: 1/8/2014

Required Date: 1/24/2014

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-75
Upper Blade Support Ass'y

Manufactured No

100 Each

1.0000

1

2

1/14.02.13

Location

Loc Qty

Loc Code

Mezz2

B111279 = 1

1

106505

1

B111805 = 2

100

Each

8.0000

1

2

1/14.02.13

PB67-43001-85
D-Pad Assembly, Long

Manufactured No

Location

Loc Qty

Loc Code

Mezz2

8

100025

4

53241

1

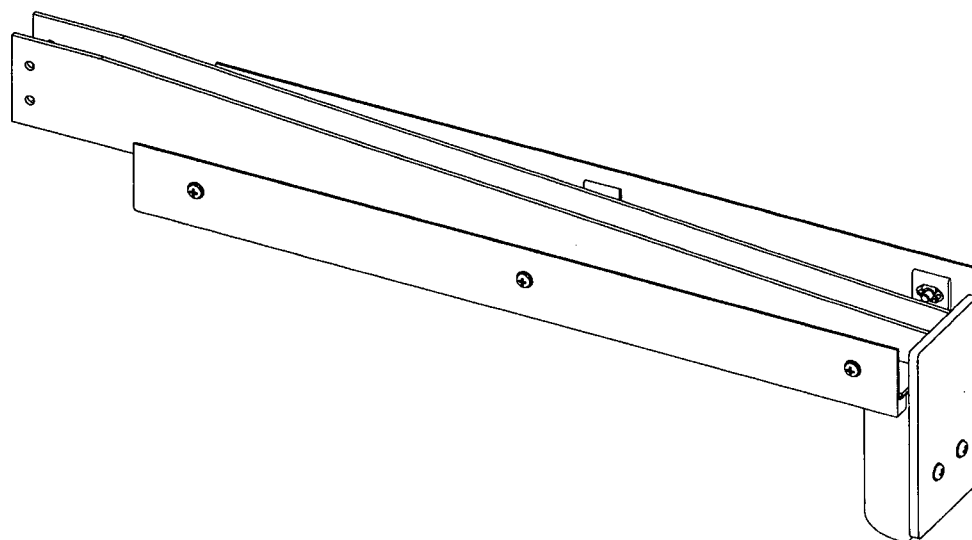
90818

3

1
3

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
3	1	B67-43001-75	LOWER BLADE SUPPORT ASSY
4	1	B67-43001-85	LONG D-PAD ASSY
5	1	B67-43001-173	COVER PLATE
7	10	MS27039-1-10	SCREW
8	10	NAS1149D0316J	WASHER
9	12	NAS1149D0363J	WASHER



B67-43001-21 UPPER BLADE SUPPORT AND COVER ASSY

mf
14-01-09
#111109

RELEASED
2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 10 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR009-011.		MB	09.07.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>AS</i>	DRAWING NO.	REV. C	
CHECKED	<i>MP</i>	B67-43001-21	SHEET 1 OF 2	
MFG. APPR.	<i>MP</i>	TITLE	SCALE	
APPROVED	N/A	UPPER BLADE SUPPORT AND COVER ASSY	NTS	
DE APPR.	N/A	DATE 09.07.28		
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

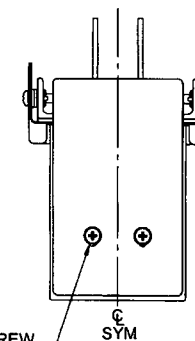
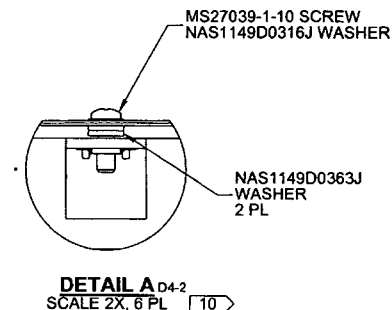
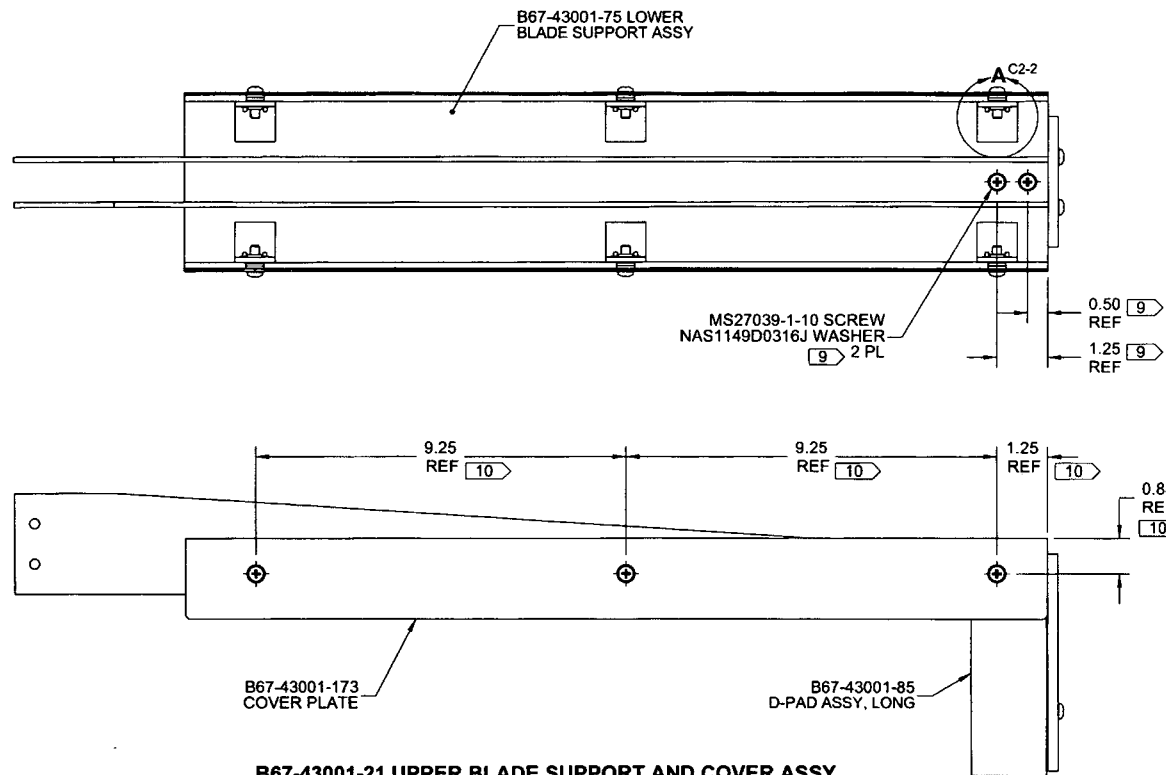
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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B67-43001-21 UPPER BLADE SUPPORT AND COVER ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.49 lbs
- 8) WELDING: PER DART QSI 004
- 9) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-173 WITH HOLE PATTERN OF B67-43001-75
- 10) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-173 WITH HOLES IN ANGLE BRACKETS ON B67-43001-75

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO	REV. C
MFG. APPR.		B67-43001-21	SHEET 2 OF 2
APPROVED	AW	TITLE	SCALE
DE APPR.	N/A	UPPER BLADE SUPPORT AND COVER ASSY	NTS
DATE	09.07.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-09-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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